Work Order II March-08-13 9:54:00			DIL		*98	166*	•						Page 1
Item ID: D293 Revision ID: Item Name: Saddle	9-2 e RH In. 206				Accept	*N9	900	040	100)*	Setup Star Stop	, 14	S1*
Start Date: 3/08/7 Required Date: 3/29/7 Reference:		t Qty: 12.00 d Qty: 12.00		*12* *12*			st Item :	ID:				·	
	ess Plan:		•	13-03-0	Tooling: SPC (Y/N):			ate:	<u>-</u> .		Run Star Stop	_ ^IV	R1* R2*
Sequence ID/ Work Center ID Draw Nbr		ription			Set Up/ Run Hours	Te	ool ID	Tool#	Plan Code		Reject Qty	Reject Number	Insp. Stamp
	Revision N	(br											
D2939	Rev C												
100 HAAS 1 HAAS CNC vertical machin		number are inspect as p	urt number and	d batch number correctly.2-Ma 9 & attached D	0.00 0.00 1-Inspect part number ichine Step No 1 of Folimension Sheet 3-Mack	and batch io and visually	, PO	13/04/	124	12	_Ø		
*110 *110* Mill Conv Conventional Milling Machin		ENTIONAL MIL Memo Machine Ko		;	0.00 0.00 ed dimension sheet	Po	13/0	SH/25			_ <i>\b</i> _		Pro
*120 *120* QC Quality Control	QC1-I	nspect dimension Memo	s to dimensio	n sheet	0.00	RI	13/04/	124			.		

NCR:	Yes	1	No
NCK.	162	/	INO

WORK ORDER NON-CONFORMANCE / UPDATE

1 A_			1
Day	Date:	13/65/25	"No.
~ 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 			

									QA Closed:	Date:	13/5/23
Work Order:	q	8160			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Order.					Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part No	$-\infty$	<u> 2939</u>	-2_		Scrap		Machining •	Small Fab		d. Eng: Coor.	Quality .
		<i></i>	. 7		Use-as-is 🔀	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	· <u>13</u> ·	- Zlel	13	-	Work Order Update		Large Fab	Composite		Supplier	ا لــا ا
	1					1 222.1	A - 4:		Cian 0		T
Root		_			ption of work order update	Initial	Acti		Sign &	Verification	QC Inspector
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descri	ption	Date	verification	QC Inspector
Doc/Data	13/04/26	tio)	Due To	deburning The Thickness one Hole where The	_	1 1 1 1		90		
Equip/Tooling	,			apound	ONE HOLE Where The	g	Heceptoble	_•	12/14/26	13/05/08	(SAS)
Operator	4			SIDT IS	lacated is under toleran				12011-	1,1,1,0	700
Material	4			64 .0		13/5/7	No effect	- eM	20	13/05/08	3/w122
Setup	4			İ		1771	Jer II de	l.s.	(a)		13/127
Other	+			K.C 0/	leratur Error.		1 11 311	ich Ziv	13/1/2	ļ	1 7,051.00
Process	-						Acceptable No effect overall struct saddle-	skid	17/3/1		
Supplier	-				· ·		interfice				
Training	-								1		
Unapproved	<u>.L.</u>	<u> </u>	<u> </u>	L	F	ULT CATE	GORY		l	<u> </u>	
Landing	Gear				General					· · · · · · · · · · · · · · · · · · ·	
	Bending			Γ_	Bend	Grain			Ovalized		Pressure/Forced
-	Centre No	nt Concer	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	 -	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	— ∶	tions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs	•			Contamination	Mainte	enance		Part Moved	<u> </u>	_
	Heat Trea	t			Countersink	Mislabe	eled		Positioned \	Wrong	
	Inspection	n Strip in	Tube	-	Cut Too Short	Misrea	d		Power Loss/	/Surge	Other
-	Ripples in	•			Drill Holes	Offset			·		
	Torque W		xtrusio	n	Drawing	Out of	Calibration				
	Turning S				Finish	Out of	Sequence				
	Wave/Tw	ist in Tub	ре		Folio	Outside	e Dimensions				

March-08-13 9:54:00 AM Item ID: D2939-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle RH In. 206 Start Date: 3/08/13 **Start Qty: 12.00** Cust Item ID: Required Date: 3/29/13 Req'd Qty: 12.00 **Customer:** Reference: Run Start ____ Date:____ Approvals: **Process Plan: Tooling:** Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Number Qty Stamp 130 QC8- Inspect parts - second check 0.00 m/13/05/08 *130* QC Memo 0.00 Quality Control 140 Chemical Conversion Coat per OSI005 4.1 0.00 12 2913.5 *140* HandFinish Memo 0.00 Hand Finishing 155 Spray Painting per QSI005 4.2 0.00 *155* SprayPaint 0.00 Memo PRIME B /25 /5.) **Spray Painting** DELFLEET BLUE B /25 476 DELFLEET CLEAR B /25053

START TIME: 11.00 FINISH TIME: 5:30

										DQA:	Date:	<u> </u>
NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	/IANCE / UP	DATE	·		
										QA Closed:	Date:	and the first and the same of
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK Olde	:I				Rework	7 I		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1 1 7		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											i	
Operator				-								·
Material										,		
Setup					•							
Other												
Process												
Supplier		1										
Training												
Unapproved						<u> </u>				<u></u>	<u> </u>	
				· · · · · · · · · · · · · · · · · · ·		AULT	CATE	GORY				
Landir	ng Gear			_	Genera!				<u></u>	1		7. /
	Bending	•		ļ	Bend	—	rain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (D/S	BOM/Route	\vdash	ardwa		ļ	Over/Under	 	Temperature/Cure
	Cracks			ļ	Broken/Damaged		•	on Incomplete	<u> </u>	Part Incorre	<u> </u>	Weld
	Crushed/	Crimped	-		Burrs	-		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
]	Cuffs				Contamination	-		nance	<u> </u>	Part Moved		
	Heat Trea				Countersink		1islabe			Positioned V	_	7 .
	Inspection	•	Tube		Cut Too Short	-	1isread	l		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		ffset					
l	Torque W	aves in E	Extrusio	ո	Drawing		ut of C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 3

March-08-13 9:54:00 AM Item ID: D2939-2 Accept *N900040100* Setup Start Revision ID: Item Name: Saddle RH In, 206 Start Date: 3/08/13 **Start Qty: 12.00** Cust Item ID: Required Date: 3/29/13 Req'd Qty: 12.00 **Customer:** Reference: Run Start Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: **SPC (Y/N):** Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number 165 QC14- Inspect Spray Paint 0.00 *165* QC Memo 0.00 Quality Control 170 Identify as per dwg & Stock Location 4354 *170* Packaging Memo 0.00 Packaging 180 QC21- Final Inspection - Work Order Release 0.00 *180* 0.00 Memo Quality Control

					•						DQA:	Date	:
NCR:	Yes /	No				WORK ORDER NON-	COL	NFORM	MANCE / UPDATE		QA Closed:	Date	
 		··· -		-1	***	DISPOSITION			AGAINST	DE	PARTMENT/		
Work Orde	er:						,					_	
Part I						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	T				Descri	ption of work order update		nitial	Action		Sign &	**************************************	
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data			· · · · · ·										
Equip/Tooling													
Operator													
Material					ļ								
Setup													
Other													
Process				-									
Supplier													
Training	Ш												
Unapproved							1				<u> </u>		
							AUL	T CATE	GORY				
Landi	ng Gear				_	General		1		_	3		7.
	Ben	-			<u> </u>	Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced
			Concer	itric to	o/s	BOM/Route	<u> </u>	Hardwa		-	Over/Under		Temperature/Cure
	Crac				<u> </u>	Broken/Damaged	<u> </u>	4 .	ion Incomplete	\vdash	Part Incorred	-	Weld
			rimped.		_	Burrs	-	4	ions Incomplete/Unclear	-	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuff					Contamination	_	Mainte		<u> </u>	Part Moved		
	Hea	t Treat			1	Countersink		Mislabe	eled		Positioned V	vrong _	<u></u>

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

March-08-13 9:54:04 AM

Work Order ID: 98166

98166

Parent Item:

D2939-2

D2939-2

Parent Item Name: Saddle RH In. 206

Start Date: 3/08/13

Required Date: 3/29/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	2.0000	1	12			
D6101-00	11								**		<i>QO</i> .	13/04	122

Location .	Loc Qty	Loc Code	
MAT042	2		
94445	2		
97770			

91239

12.0

NCR: Y	es / No				WORK ORDER NON-	-COI	NFORI	MANCE / UP	DATE			•
, ,	,							•		QA Closed:	Dat	e:
Morle Orde					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
Work Orde	ži				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	-	!	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier[
Root		<i>i</i>		Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data												
quip/Tooling											-	
Operator									•			
Material												
Setup												
Other							•					
Process								-				
Supplier												
Training												
Unapproved		<u> </u>	<u> </u>							L		
	<u> </u>					FAUI	T CATE	GORY	2.200			
Landir	ng Gear				General		1		·	1		Pressure/Forced
	Bending				Bend	-	Grain		 	Ovalized	4 - 1	
	Centre N	ot Conce	ntric to (^{O/S} _	BOM/Route	-	Hardwa		<u> </u>	Over/Under		Temperature/Cure
	Cracks			ļ	Broken/Damaged		1	ion Incomplete	 	Part Incorre		Weld
	Crushed/	Crimped		-	Burrs	<u> </u>	1	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	-	Mainte		-	Part Moved	• • • • • • •	
	Heat Trea			<u> </u>	Countersink	-	Mislabe			Positioned V	-	Othor
	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misread	i e	<u> </u>	Power Loss/	Surge	Other
	Ripples ir		_	\vdash	Drill Holes	<u> </u>	Offset	~ 121				
	Torque V			` _	Drawing	<u> </u>	1	Calibration				
	Turning S	COMMONCO		I	Einich	- 1	IOut of 9	Seguence				

Outside Dimensions

DQA: Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	98/16
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First A	Г	Proto		. 1	
			X THSE F					
					Record	Actual Din	nensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Α	0.100	0.140		115	4114	114	-112	1115
В	0.100	0.140		-116	iis	. 115_	.113	. 115
С	0.100	0.140		8110	. 03	-115	-114	-115
D	0.210	0.230		250	. 220	.219	-218	.219
E	1.245	1.255		1.250	1.250	1.250	1,255	1.250
F	1.245	1.255		1.250	1.250	1.250	1,250	1.250
G	2.495	2.505		5 'Z.co	2.500	2.500	2.500	2.500
Н	0.510	0.515		. 514	.514	.514	-514	.54
1	1.572	1.582		1.577	1.577	1577	1,577	1.577
J	2.495	2.505		5,500	2.500	2,500	2.500	2.500
K	0.257	0.262		,253	258	.258	.2SP	.258 -
L	0.312	0.317		.314	.34	314	3H	.314
М	0.235	0.240		. 237	.237	.736	. 237	.237
N	0.100	0.140		121	- 120	.119	, 119	. 119
0	0.540	0.560		<u>"551</u>	.551	-551	15S	-551
Р	0.490	0.510		.500	- 498	.497	.497	.497
Q	3.715	3.725		3.7.20	3.720	3 720	3720	3 720
R	2.720	2.760		2.742	2 740	2.740	2 740	2.750
S	0.240	0.270		.250	250	.249	249	- 249
T	0.100	0.180		₃ 130	. 130	.130	(30	.130
U	1.625	1.635		1.630	1.630	1.630	1,630	1,630
V	1.362	1.372		1.367	1.367	1.367	1.367	1 367
W	0.316	0.321		· 3(6	.316	.316	316	.316
Χ	1.250	1.270		1.260	1.262	1.261	1260	1.260
Υ	1.565	1.585		1.579	1,576	1.575	1.574	1,574
Z	0.178	0.198		.188	.188	188	188	.138
AA								
AB				- '.				
AC								
AD								
		_ . :	Accept/Reject				V	
	Measure	d by: FK /	'Po			Date	13/04/2	-4
	Audite	d by:	mZ			Date	13/05	108
Proto	type Appr	oval:	N	1/A		Date	: \	I/A
Rev	Date	Change					vised by	Approved
Α		New Issue				RF		
В	02.12.12	Re-format; A DT8695 A/B	dded Dim. X-Y,	DT8683, DT	8686, DT869	0 & KJ	/RF	

KJ/JLM KJ/EC/DD

07.03.21 Revised per drawing revision C 07.11.23 DT8695 A/B removed

DART AEROSPACE LTD	Work Order:	98/46
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

mspe	ction Dwg:			Rev:	DIMENCIA	ON OUE		ge 1 of 1	
		FIRST	ARTICLE INS	r	Proto		EI		
				Record Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	16	21	2 8	A a	10	
Α	0.100	0.140		.112	112	.114	112	117	
В	0.100	0.140		1/3	112	114	117	112	
С	0.100	0.140		. 1/5	. 115	.116	114	. 44	
D	0.210	0.230		219	. 718	. 719	,218	. 218	
E	1.245	1.255		1.250	1250	1250	1.250	1.250	
F	1.245	1.255		1,250	1,250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2500	2500	2 500	
Н	0.510	0.515		-51-1	1514	.514	.514	. 514	
1	1.572	1.582		1577	1,577	1,577	1,577	1551	
j	2.495	2.505		2.500	2500	2.500	2.500	7.500	
K	0.257	0.262		.258	750	258	.258	758	
	0.312	0.317		244	3,4	.314	314	.314	
M	0.235	0.240		.737	727	237	237	237	
N	0.100	0.140		- 170	110	119	118	118	
Ö	0.540	0.560		551	350	.550	1.551	551	
P	0.490	0.510		- 502	. S00	.499	ं पंबेर्र	499	
· Q	3.715	3.725		3 720	3.720	3 720	3 770	3 720	
R	2.720	2.760		2.740	2 740	2 740	2 740	2 740	
S	0.240	0.270		.749	249	.249	249	200	
T	0.100	0.180		.130	- (30	. 120	130	130	
ÜΠ	1.625	1.635		1.630	1.630	1,630	1650	1,630	
Ϋ́	1.362	1.372		1367	1.367	1,367	1:367	1367	
ŵ	0.316	0.321		136	1.331	.316	-316	316	
X	1.250	1.270		1,260	1,260	1,261	1.260	1260	
Ŷ	1.565	1.585		1574	1.574	1.575	1.574	1,574	
ż	0.178	0.198		7.187	1.37	.188	.18%	188	
AA	0.170	0.100			-700	- (00		100	
AB		<u> </u>			-				
AC		<u> </u>			-				
AD					 			 	
- 74	<u> </u>		Accept/Reject	-		1	1		
	Moseuro		, сосоранојос	l		Date	e: 13/64/2	><	
Proto							N/A		
Rev	Date	Change					Revised by	Approved	
A		New Issue	1.0				RF		
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 DT8695 A/B							
c	07.03.21	Revised per drawing revision C					KJ/JLM		
Image: Control of the	07.11.23	DT8695 A/B removed KJ/EC/DD						10/	
<u> </u>	101.11.23	210033 A/D	I CITIO V C U				···-		

DART AEROSPACE LTD	Work Order:	98/46
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

шэрс	cuon Dwg:		ARTICLE INS	Rev:	DIMENSIO)N SH	IFFT		ge 1 of 1	
	X First A			1	Prototype					
							ual Dimensions			
Dim	Min	Max	Go/No Go Gauge	i 1	12	18		A	15	
Α	0.100	0.140		. 118	117					
В	0.100	0.140		. 118	8۱۱ و					
С	0.100	0.140		.117	. 116					
D	0.210	0.230		218	. 218					
Е	1.245	1.255		1.250	1.250					
F	1.245	1.255		i.250	1.250					
G	2.495	2.505		1.50	2.500					
Н	0.510	0.515		. 514	-514					
_	1.572	1.582		1.577	1.577					
J	2.495	2.505		2.500	2.500					
ĸ	0.257	0.262		.258	.258					
ᆫ	0.312	0.317		-314	-314					
М	0.235	0.240		.233	.235					
N	0.100	0.140		.118	118					
0	0.540	0.560		.351	1,551					
Р	0.490	0.510		.500	.500					
Q	3.715	3.725		3.720	3.770					
R	2.720	2.760		2,740	2.140					
S	0.240	0.270		-248	.248					
Т	0.100	0.180		130	.130					
U	1.625	1.635		1,630	1,630				ļ	
V	1.362	1.372		1.367	1.367				<u> </u>	
W	0.316	0.321		.316	316				ļ	
X	1.250	1.270		1.260	L257					
Υ	1.565	1.585		1.575	1,572					
Z	0.178	0.198		1881.	881.					
AA						·				
AB					ļ				-	
AC					<u> </u>					
AD			Accept/Reject							
\pm	Measure						ate:	13/04/26		
_	Audited by: onl						Date: 13/05/88			
Proto	otype Appr			1/A			ate:		V/A	
Rev	Date	Change						ised by	Approve	
A		New Issue					RF		1	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B					KJ/F	RF		
c	07.03.21	Revised per drawing revision C					KJ/J	ILM	 	
	+	Trovisca per drawing revision o							+ N1	

07.11.23 DT8695 A/B removed

